

Setup today please

Work Order ID 69836

Friday, May 20, 2011 7:46:30 AM



Page 1

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-05-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9500

A

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9500-011
CHG001

Sulcstzo

MF 11-5-20

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11-5-20 SP2

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulcstzo

42

Work Order ID 69836

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Page 2

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP DSI9500-011 Location: _____ PPP rev: <u>PNDFT</u>	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Picklist Print

Friday, May 20, 2011 7:46:25 AM

Page 1

Work Order ID: 69836

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/20/2011

Required Date: 5/20/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7 Mounting Lug		Manufactured	No			110	Each	63.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST470		63							
				62929		31							
				66427		32							
D2732-030 Rubber Cushion		Manufactured	No			110	Each	56.0000	8	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		52							
				69205		52							
				ST410		4							
				56516		2							
				65395		2							
D3394-043 Lug Assembly		Manufactured	No			110	Each	84.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST475		84							
				62930		20							
				62976		30							
				66429		34							

X8 Per Kit → measure
@ 3.0" 18 units

4

B64283 SP

4

11/5/20 SP20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69836

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/20/2011

Required Date: 5/20/2011

Start Qty: 2.00

Required Qty: 2.00

D4064-041

Manufactured No

110

Each

25.0000

1



Mounting Lug

Location

Loc Qty

Loc Code

ST462

18

62977

18

ST464

7

58980

6

58985

1

AN4C13A

Purchased

No

110

Each

11.0000

4



BOLT

Location

Loc Qty

Loc Code

ST361

11

117688

11

AN4C14A

Purchased

No

110

Each

70.0000

4



Bolt

Location

Loc Qty

Loc Code

ST337

40

117688

40

ST357

30

117366

30

AN4C15A

Purchased

No

110

Each

59.0000

4



Bolt

Location

Loc Qty

Loc Code

ST358

59

115936

3

117441

56

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69836

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/20/2011

Required Date: 5/20/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C416 NAS1149C0463 Purchased No

110 Each 0.0000 16 32



washer



M115358

M117735

AN960C416L NAS1149C0432L Purchased No

110 Each 0.0000 8 16



WASHER



M116900

NAS1515H4L Purchased No

110 Each 286.0000 24 48



WASHER



48

Location

Loc Qty

Loc Code

FG 40

103691 40

ST277 246

117363 246

MS21043-4 Purchased No

110 Each 1,258.000 12 24



Nut



24

Location

Loc Qty

Loc Code

FG 40

104603 40

ST300 600

117423 600

ST301 618

116188 -12

116549 130

117601 500

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE
REF TCCA STC: SH98-14
REF EASA STC EASA.IM.R.S.01339

REFERENCE ONLY

8

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	GP		
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

REFERENCE ON

THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY	Part Number	Description
-011		
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

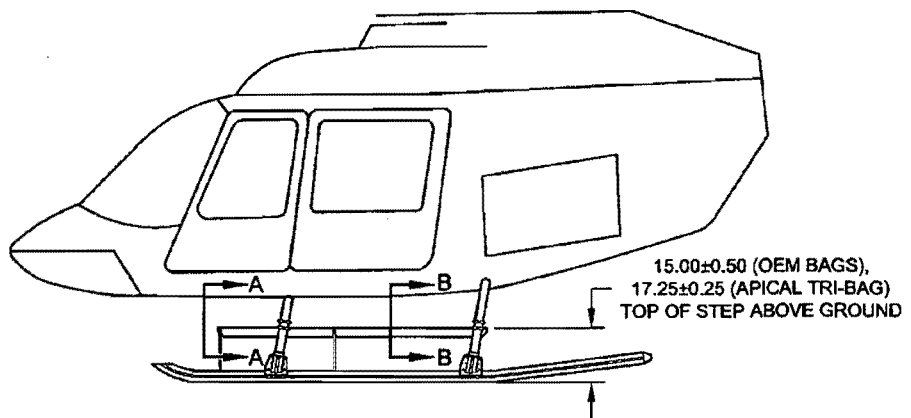
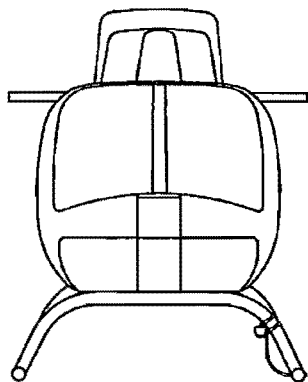
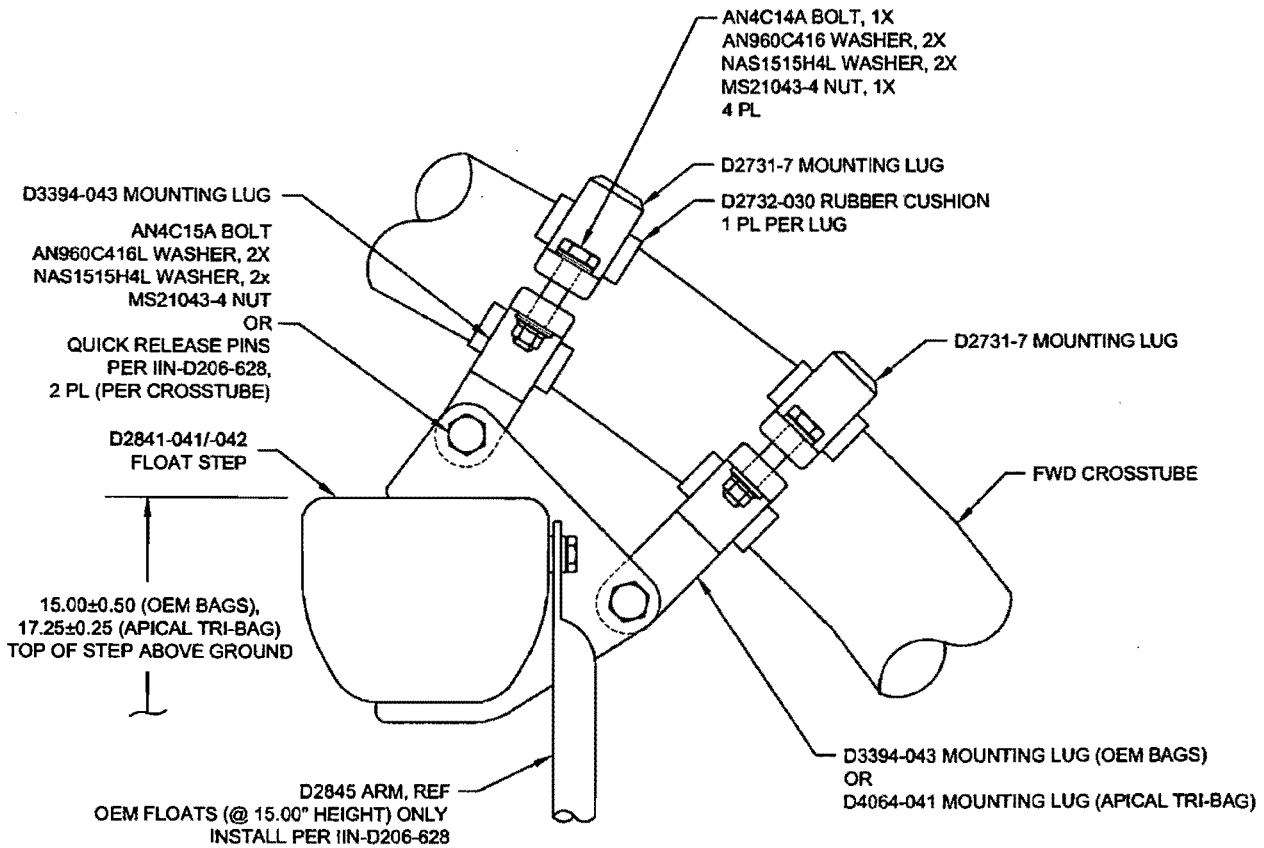


FIGURE 1

D206-628-013 (SHOWN) / -014 (OPPOSITE)
206 A/B FLOAT STEP INSTALLATION

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 2 OF 4
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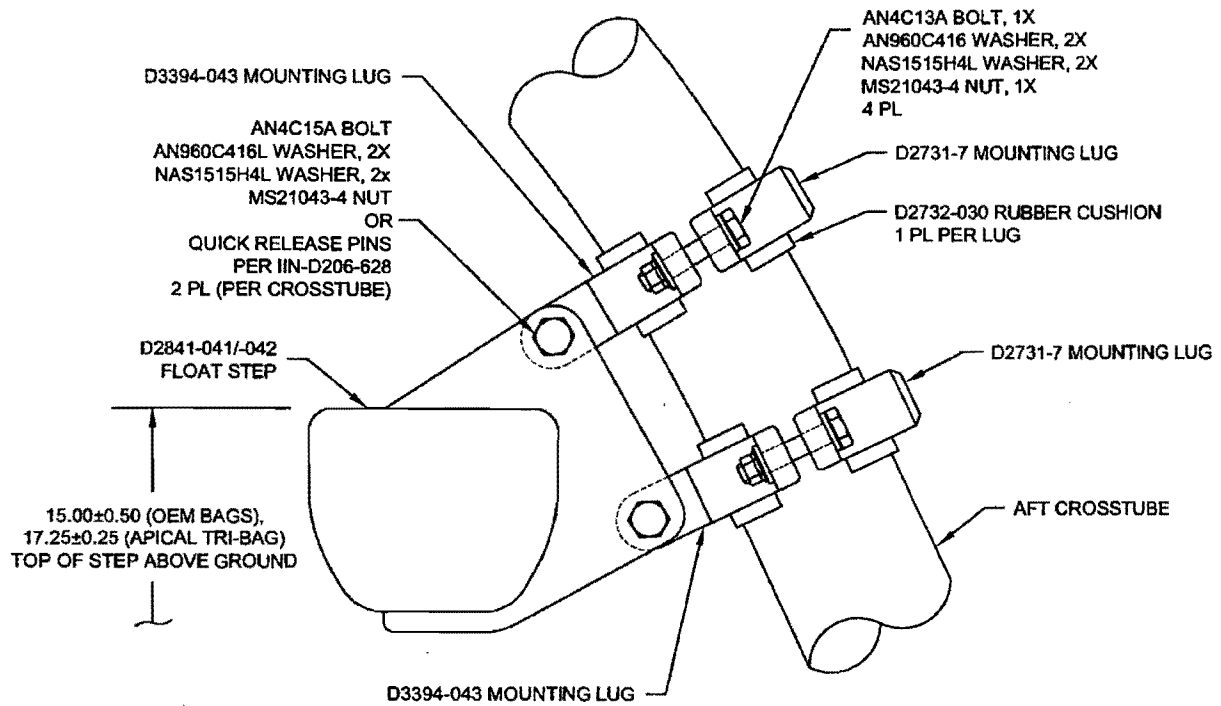
REFERENCE



SECTION A-A
FWD CROSSTUBE CLAMPING DETAIL

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 3 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	MOUNTING LUG CHANGE	NTS
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REFERENCE



SECTION B-B
AFT CROSSTUBE CLAMPING DETAIL

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DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
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